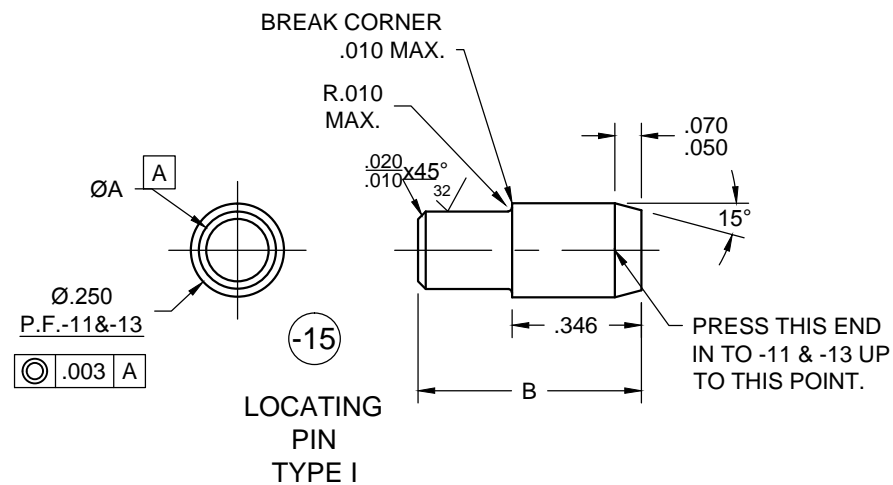
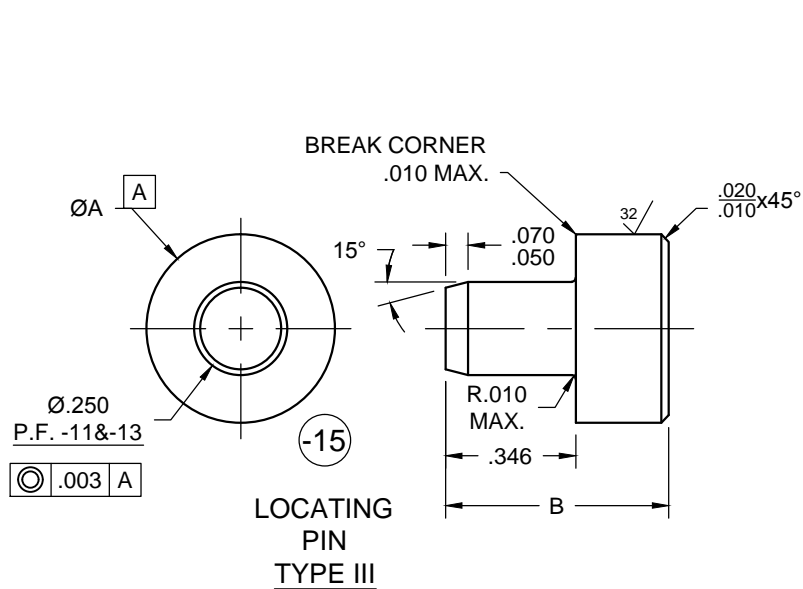


- NOTES**
1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +.030 -.030	ØB P.F.-1	ØC +.020 -.000	MATERIAL
KSTKDSY5-5	2.000	1.812	1.506	CDS TUBING Ø2 x 1/4 wall x 1/2

<b>RED BARN MACHINE</b>			
TITLE KSTKDSY## SERIES SWAGING TOOL; LOCATING PIN			
DWG NO. TOOL# (see chart)-17			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES		DRAWN BY: PERRITT	
TOLERANCES ON:		APPROVED	
DECIMALS		HEAT TREAT	
XXX ± .005		FINISH	
XX ± .01		SPEC	
X ± .1		BLACK OXIDE	
FRACTIONS ± 1/32		USED ON BEARING	
ANGLES ± 5°		SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 2-16-09	SHEET 10 of 10	

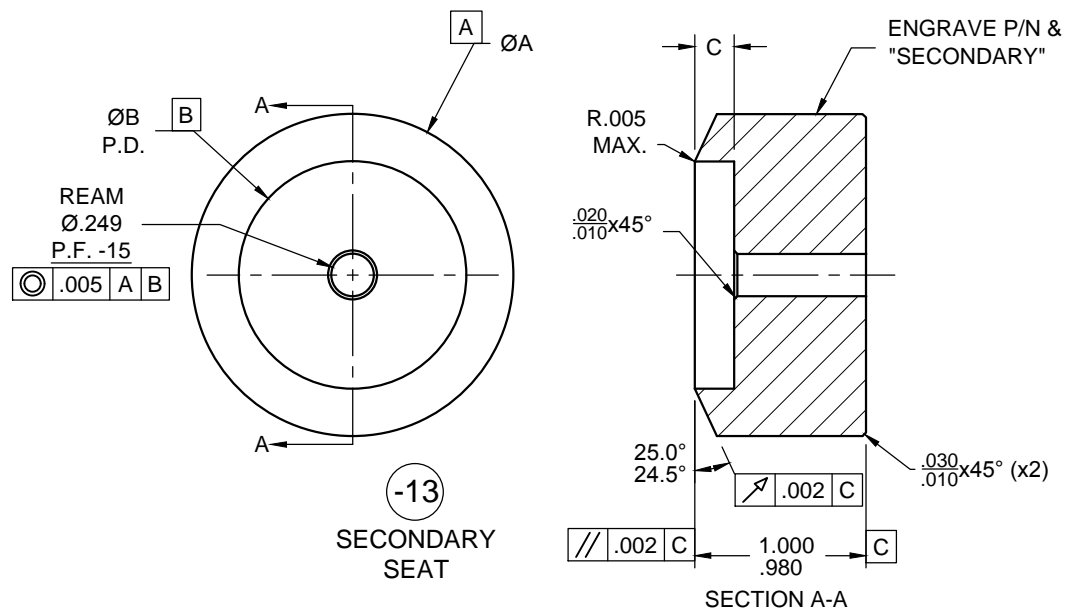


# NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

TOOL #	ØA +0.00 -0.02	B +0.01 -0.01	PIN TYPE	QTY.	MATERIAL
KSTKDSY5-5	.309	.710	III	2	1018 RND. BAR Ø3/8 x 7/8

RED BARN MACHINE			
TITLE KSTKDSY## SERIES SWAGING TOOL; LOCATING PIN			
DWG NO. TOOL# (see chart)-15			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 X ± .1		FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
SCALE	NTS	DATE	2-16-09
SHEET		9 of 10	

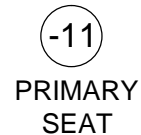


#### NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).


TOOL #	ØA +0.00 -0.02	ØB +0.005 -0.000	C +0.020 -0.000	MATERIAL
KSTKDSY5-5	1.250	.806	.337	4140 Q&T RND. BAR Ø1-1/4 x 1-1/8

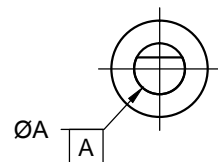
<b>RED BARN MACHINE</b>			
TITLE KSTKDSY## SERIES SWAGING TOOL; SECONDARY SEAT			
DWG NO. TOOL# (see chart)-13			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING			
SCALE NTS	DATE 8-13-08	SHEET 8 of 10	



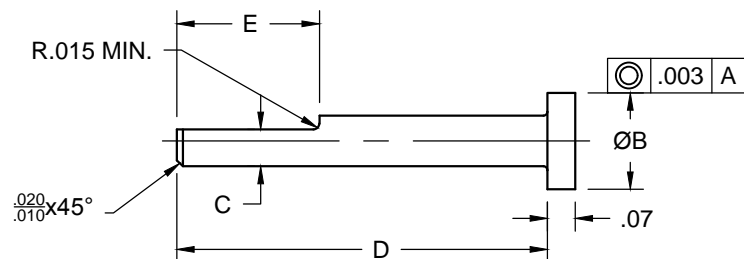
NOTES

1. BREAK ALL SHARP CORNERS (.015/.03).

 <b>RED BARN MACHINE</b>			
<b>TITLE</b> KSTKDSY##    SERIES SWAGING TOOL; PRIMARY SEAT			
<b>DWG NO.</b> TOOL# (see chart)-11			<b>REV</b> 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± .5°		<b>DRAWN BY:</b> PERRITT <b>APPROVED</b>	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		<b>HEAT TREAT</b>	
		<b>FINISH SPEC</b> BLACK OXIDE	
		USED ON BEARING <b>SEE Pg. 1</b>	
<b>SCALE</b> NTS	<b>DATE</b> 2-16-09	<b>SHEET</b> 7 of 10	



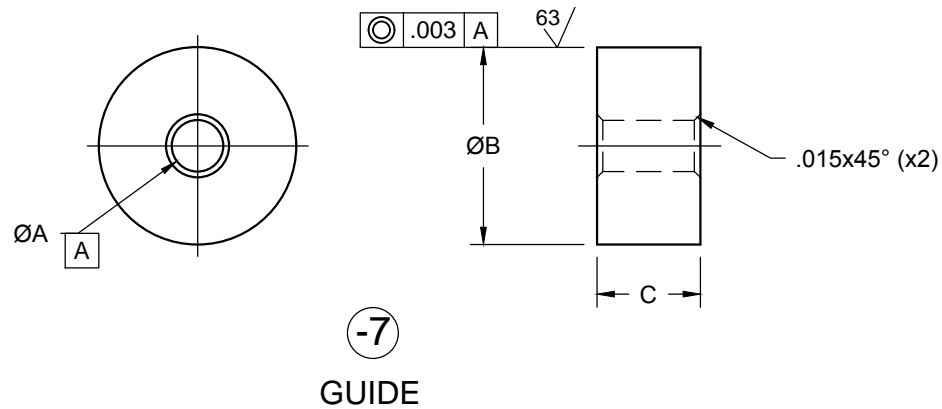
-9  
PIN



TOOL #	ØA +0.00 -0.01	ØB +0.005 -0.005	C +0.010 -0.010	D +0.010 -0.010	E +0.010 -0.010	MATERIAL
KSTKDSY5-5	.129	.188	.104	.768	.313	MCMaster-CARR PN: 98378A909

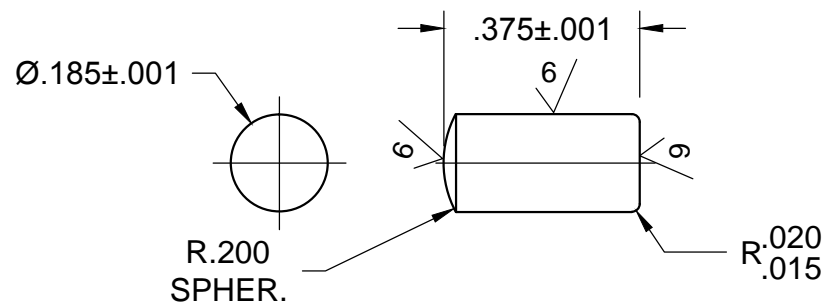
NOTES  
1. BREAK ALL SHARP CORNERS (.015/.03).


RED BARN MACHINE			
TITLE KSTKDSY## SERIES SWAGING TOOL; PIN			
DWG NO. TOOL# (see chart)-9			REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1		DRAWN BY: PERRITT APPROVED HEAT TREAT FINISH SPEC BLACK OXIDE USED ON BEARING SEE Pg. 1	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		SCALE NTS DATE 2-16-09 SHEET 6 of 10	

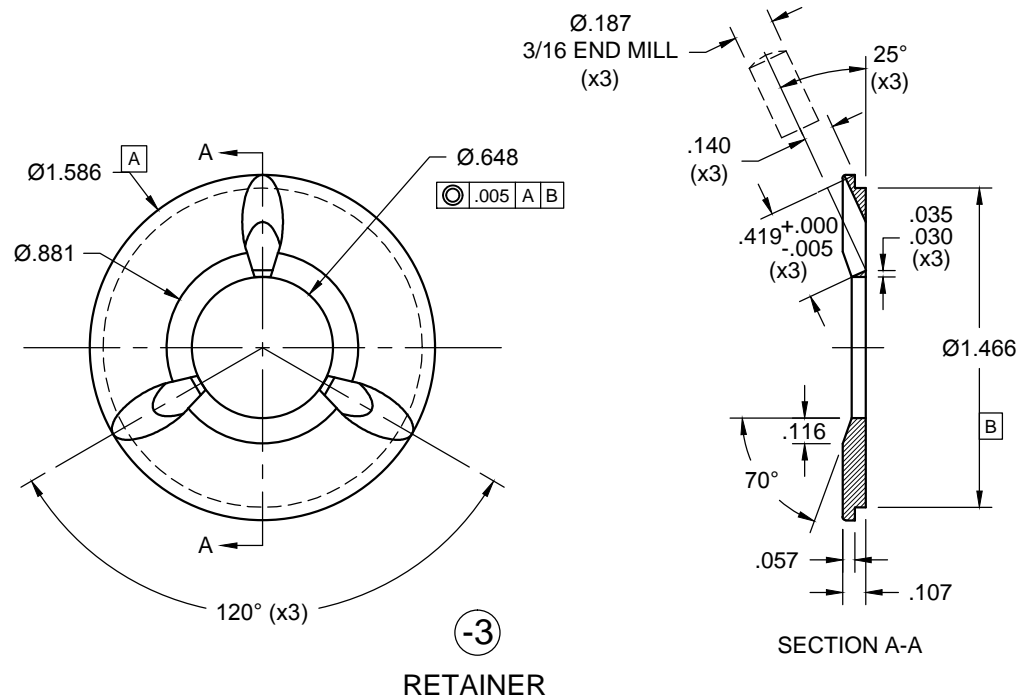


TOOL #	ØA +.001 -.001	ØB +.000 -.002	C +.000 -.010	MATERIAL
KSTKDSY5-5	.131	.309	.300	BRONZE RND. BAR Ø3/8 x 1/2

<b>RED BARN MACHINE</b>			
<b>TITLE</b> KSTKDSY## SERIES SWAGING TOOL; GUIDE			
<b>DWG NO.</b> TOOL# (see chart)-7			<b>REV</b> 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005      FRACTIONS ± 1/32 .XX ± .01      ANGLES ± 5° X ± .1		<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> HEAT TREAT FINISH SPEC USED ON BEARING <b>SEE Pg. 1</b>	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		<b>SCALE</b> NTS <b>DATE</b> 2-16-09 <b>SHEET</b> 5 of 10	

[illegible]

 <b>RED BARN MACHINE</b>	
<b>TITLE</b> KSTKDSY## SERIES SWAGING TOOL; ROLLER (QTY. 3)	
<b>DWG NO.</b> TOOL# (see chart)-5	<b>REV</b> 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: <b>PERRITT</b> APPROVED _____ HEAT TREAT _____ FINISH _____ SPEC _____
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON BEARING _____ SEE Pg. 1 _____
<b>SCALE</b> NTS	<b>DATE</b> 2-21-90 <b>SHEET</b> 4 of 10



- NOTES**
1. BREAK ALL SHARP CORNERS (.015/.03).

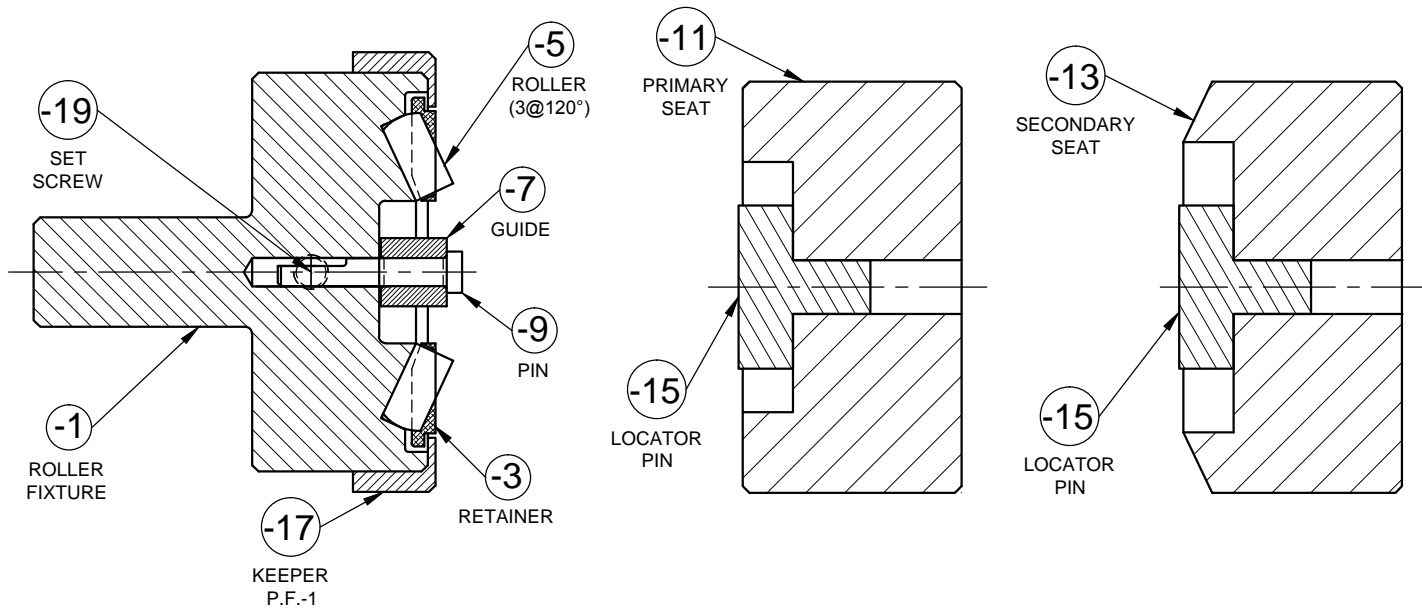
TOOL #	ØA +0.02 -0.02	ØB +0.010 -0.005	C +0.010 -0.000	ØD +0.002 -0.002	ØE +0.002 -0.002	F +0.010 -0.010	G +0.002 -0.002	H +0.005 -0.000	ØJ +0.002 -0.000	K +0.005 -0.000	ØL +0.010 -0.005	ØM +0.002 -0.002	P.D. REF.	MATERIAL
KSTKDSY5-5	-	-	-	-	-	-	-	-	-	-	-	-	.806	BRONZE RND. BAR Ø1-3/4 x 1/4

<b>RED BARN MACHINE</b>	
<b>TITLE</b> KSTKDSY## SERIES SWAGING TOOL; RETAINER	
<b>DWG NO.</b> TOOL# (see chart)-3	<b>REV</b> 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	<b>DRAWN BY:</b> PERRITT <b>APPROVED</b> HEAT TREAT FINISH SPEC USED ON BEARING SEE Pg. 1
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
<b>SCALE</b> NTS	<b>DATE</b> 2-16-09 <b>SHEET</b> 3 of 10



[illegible]

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	-1 CH'D TOLERANCE (H) WAS +/- .002 IS +/- .005.	6/17/13	BIM	GE



#### NOTES

1. -5 ROLLERS MUST TURN FREELY IN -3 RETAINER POCKETS.
2. -5 ROLLERS & -3 RETAINER MUST TURN FREELY WHEN TOOL IS COMPLETELY ASSEMBLED.
3. FLAT END OF ROLLERS MUST FACE TOWARDS THE CENTER OF THE TOOL WHEN ASSEMBLED.

BEARINGS & TOOLS COVERED	
BEARING #	TOOL #
KDSY5-5	KSTKDSY5-5


ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	B/O INFORMATION OR SPECIFICATIONS	Pg.
		-1	1	ROLLER FIXTURE	SEE CHART	2
		-3	1	RETAINER	SEE CHART	3
		-5	3	ROLLER	SEE CHART	4
		-7	1	GUIDE	SEE CHART	5
		-9	1	PIN	SEE CHART	6
		-11	1	PRIMARY SEAT	SEE CHART	7
		-13	0 or 1	SECONDARY SEAT	SEE CHART	8
		-15	1 or 2	LOCATING PIN	SEE CHART	9
		-17	1	KEEPER	SEE CHART	10
B/O		-19	1	SOCKET HEAD SET SCREW	#8-32 x 1/4	N/S

**RED BARN MACHINE**

TITLE KSTKDSY## SERIES TRI-ROLLER SWAGING TOOLS	
DWG NO. TOOL # (SEE CHART ABOVE)	REV 1
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	
FRACTIONS ± 1/32 ANGLES ± 5°	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 2-16-09
SHEET 1 of 10	

DRAWN BY: PERRITT	APPROVED
HEAT TREAT LISTED PER ITEM	FINISH SPEC LISTED PER ITEM
USED ON BEARING	
SEE ABOVE	

[illegible]

 <span>RED BARN MACHINE</span>	
TITLE <span style="float: right;">--</span>	
DWG NO. <span style="float: right;">--</span>	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1 FRACTIONS ± 1/32 ANGLES ± 5°	DRAWN BY: <b>PERRITT</b> APPROVED HEAT TREAT FINISH SPEC
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL   
SCALE <b>NTS</b>	DATE <b>8-15-07</b>
SHEET <b>1 of 1</b>	

NOT APPROVED FOR PRODUCTION

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED

PART #	QTY	DESCRIPTION
-1	1	--

DRAWN BY: PERRITT	<div>RB</div> RED BARN MACHINE		
CHECKED	TITLE		
HEAT TREAT FINISH SPEC	TITLE		
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	FRACTIONS ± 1/32 ANGLES ± .5°		REV.
USED ON MODEL ?	DWG NO. PART #		
	SCALE NTS	DATE 1-28-06	SHEET 1 of 1
	UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING		